



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-1

Job Sheet 170992



53
Job Qty: 50 ea

Part No: D3065-1

Part Name: Step Spacer



Part Weight: 0 lbs

Job Created: 1/25/18

Due Date: 2/5/18

Type: Stock

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP:

Shlp Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		2/3/18	0.00	0.00	Start Up Waterjet		pc 18/01/28
100	Waterjet	50 pcs		2/3/18	0.00	1.77	Waterjet1		pc 18/01/28
120	QC	50 pcs		2/3/18	0.00	0.00	QC8		EB
132	Brake NC	50 pcs		2/3/18	0.02	1.34	Brake NC 2		FFS
150	QC	50 pcs		2/3/18	0.00	0.00	QC5		EB
160	HandFinish	50 pcs		2/5/18	0.00	0.73	HandFinish1		19.02-01
161	QC	50 pcs		2/5/18	0.00	0.00	QC7-1		EB
180	Packaging	50 pcs		2/5/18	0.00	0.00	Packaging3-1		GA
190	QC21-SA	50 Ea		2/5/18	0.00	0.00	QC21		med. 18/02/01

Part Op 100 - 1-Cut as per Dwg D3065

Descriptions: 180 - LOCATION : GA

013
21
9-ED FEB 07 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	6.1900 sf (.1238 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	6	96	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS	
Date: _____		Step #: _____		Water Jet ☐ Prod. Eng. Coord. ☐ Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐	
Description Work Order Deviation		Suspected Un		MRB (QSI042) Approval	
		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐			
Design ☐	Operator ☐	Bending ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐			
Material ☐	Use for Testing ☐	Cuffs ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER: _____			

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE
S036204

Step Spacer

D3065-1
PART NO:
Original Serial #: S036204
Revision:
Operation:
Change No:

Start up Operation 01/28/18
Job No: 170992

irge	☐	Positioned Wrong
	☐	Outside Dimensions
	☐	Over/Under tolerance
	☐	Part Incorrect
illed e	☐	Part Lost/Missing
	☐	Part Moved
	☐	Drawing
	☐	Finish
	☐	Misread
	☐	Turning Sequence

misaligned/off center

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250inches $\pm$ 0.010	0.260 0.240		
2	Step Spacer	2.093inches $\pm$ 0.010	2.103 2.083		
3	Step Spacer	3.936inches $\pm$ 0.010	3.946 3.926		
4	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176		
5	Step Spacer	0.587inches $\pm$ 0.010	0.597 0.577		
6	Step Spacer	0.128inches $\pm$ 0.005 - 0.001	0.133 0.127		
7	Step Spacer	0.125inches $\pm$ 0.010	0.135 0.115		
8	Step Spacer	3.465inches $\pm$ 0.010	3.475 3.455		
9	Step Spacer	1.250inches $\pm$ 0.012 - 0.001	1.262 1.249		
10	Step Spacer	0.368inches $\pm$ 0.010	0.378 0.358		
11	Step Spacer	0.871inches $\pm$ 0.005	0.876 0.866		
12	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					